Work Order I November 4, 2009		1 -	12/ onle	LEADY 200	esteble (	<u>.                                    </u>					Page 1
	136-041			Accept				s	etup Start		
Revision ID: E Item Name: Wir	ndow Assemb	bly							Stop		
Start Date: 11/0 Required Date: 11/0 Reference:		Start Qty: 1.00 Req'd Qty: 1.00		<b>a</b> 1	Cust Item I Customer:	D:					
	rocess Plan:	$- \mathcal{N}_{-}$	Date:	Tooling:		ite:		R	un Start Stop	1 1330101 301	
	C:		Date:	SPC (Y/N):	Da	ate:					
Sequence ID/ Work Center ID		Operation Control Operation		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisi	ion Nbr								<del></del>	
D3136	Rev E										
Waterjet FLOW CNC Waterjet	Ĭ	FLOW WATER JET Memo	E   E	0.00					B.	<u>i-11-4</u>	<u> </u>
QC Quality Control	(	QC2- Inspect parts o	ff machine FAI/FAIB	0.00					R	₹(- <b>-</b> 4	
120 QC Quality Control	,	QC8- Inspect parts - Memo	second check	0.00	luloy			(fd)	<b>¢</b>	i de Remarko de Arrigo (de 1	



November 4, 2009 10:04:50 AM

Item ID:

D3136-041

**Revision ID:** 

Ε Item Name: Window Assembly

**Start Date:** 

11/04/09

Required Date: 11/05/09

Start Qty: 1.00



Accept

Setup Start

Stop

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Operation

Description

**Reg'd Qty:** 1.00

Date: \_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Draw

Number

Date:

Draw

Rev.

Plan

Code

Date:

Reject

Qty

Run

Accept

Qty

Start



Stop

Reject Insp.

Number Stamp

Sequence ID/ **Work Center ID** 

130

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

0.00

0.00

1-Thermoform as per Dwg D3136 and Folio FTA006□Dwg

□2- Engrave Part # and

140

QC

**Quality Control** 

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DL 09/4/04

150

Quality Control

OC8- Inspect parts - second check

0.00

Memo

GURAP MF 09-11-06

0.00

#### Page 3

# Work Order ID 53429

November 4, 2009 10:04:51 AM



Item ID:

D3136-041

Accept

Setup Start



**Revision ID:** Item Name:

E

Required Date: 11/05/09

Window Assembly

**Start Date:** 

11/04/09

Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:

Date:

Run

Reject

Qty

Start

Stop

Approvals:

Tooling:

**SPC (Y/N):** 

Date:

Stop

Sequence ID/

Work Center ID

**Operation Description**  Set Up/ **Run Hours**  Draw Number

Plan Draw Rev. Code

Accept Qty

Reject Number

160

Thermoform

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Thermoforming Machine

Water sand and buff to remove scractches as required

170

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location:\_\_\_\_\_

0.00

Memo

0.00

180

0.00

Memo

0.00

Packaging

Insp.

Stamp

Quality Control

Packaging

## Work Order ID 53429

Ε

Required Date: 11/05/09

November 4, 2009 10:04:51 AM



Page 4

Item ID:

D3136-041

Accept



Setup Start

Stop



**Revision ID:** Item Name:

Window Assembly

**Start Date:** 

11/04/09

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Draw

Number

Reference:

<del></del>			- n <del>m m m m m m</del>		Run	Start
Approvals:	Process Plan:	Date:	Tooling:	Date:		Ston
	OC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ **Work Center ID**  Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject

Insp.

190

Memo

0.00

**Quality Control** 

0.00

Number Stamp

## **Picklist Print**

November 4, 2009 10:04:49 AM

Work Order ID: 53429

Parent Item:

D3136-041RevE

Parent Item Name: Window Assembly



**Start Date:** 11/04/09

Required Date: 11/05/09

B9-11-4

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-9RevB1		Manufactured	No			100	Each	804.0000	2.0000			<del></del>

Decal

Comments:

Warehouse		Loc Qty	Loc Code		~	
<u>Location</u>	<u>1</u>				$\mathcal{O}$	
Main Wareh	ouse					
ST		804				
34	554	316				
46	546	488				
No	170	sf	198.8491	4.4737		

MACRLICS.125 Purchased

1/8" Polycast II Sheet

Warehouse	Loc Qty	Loc Code
<b>Location</b>		

Main Warehouse MAT 198.8491 110115 110633 17.2295 111711 67.7447 112888 109.8749

117888

DART AEROSPACE LTD	Work Order:	53427
Description: Window Assembly	Part Number:	D3136-1
Inspection Dwg: D3136 Rev: E		Page 1 of 1

	FIRST	ARTICLE II	NSPECTI	ON CHI	ECKLIST		
	x	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
27.50	+/-0.030	27.50	<b>X</b>				
22.63	+/-0.030	22.685	<b>1</b> 00				
3.70	+/-0.030	3,708	×				
0.06	+/-0.030	,077	<b>&gt;</b>				
		1.4					
07.	4-0.30	27/7	Oh I				
27.50	V- 0.30	22.625	Ph /				
724.5	7-0.30	J-4603					
	·						
						-	
					<del> </del>		
					· · · · · · · · · · · · · · · · · · ·		
					*		
			<u> </u>	<u> </u>			
		A . 414 - 4 4-		<del></del>	Brototypo	Approval:	N/A
Measured by:	B	Audited by:	<u> </u>	//	Prototype		
Date:	9-1-4	Date:	orlalo	<b>/</b>		Date:	N/A
Rev Date	Change					Revised	Approved
A 09.05.04	New Issue	P/O D	3136-041			KJ/DD	41



